

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013777**Date Inspected:** 16-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 11DE, weld No.SEG-072A-015. The welder is identified as #067665. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 11DE, weld No.SEG-072A-009. The welder is identified as #044772. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 1G position for the OBG Segment 12AE, weld No.SEG3001A-001. The welder is identified as #058551. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U2-F.

FCAW in the 1G position for the OBG Segment 12CE , weld No.SEG3003*-008. The welder is identified as #048038. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with

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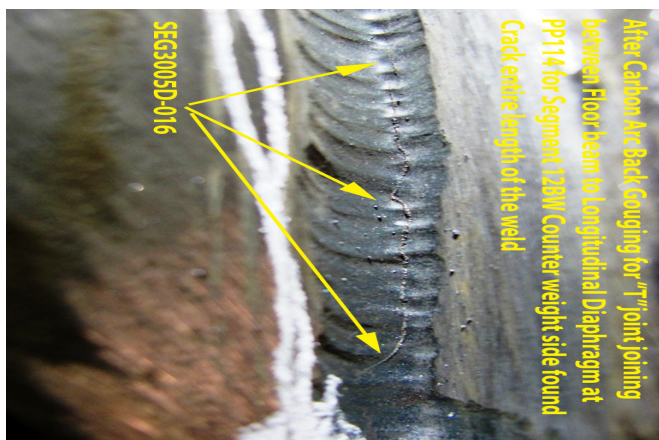
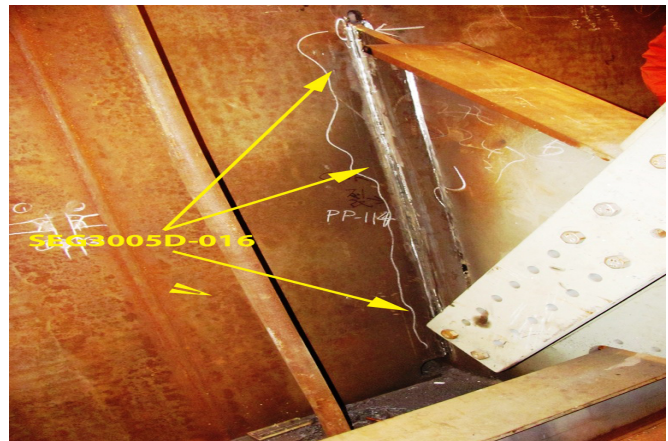
(Continued Page 2 of 4)

WPS-B-T-2231-B-U2-F.

During random visual inspection the QA inspector observed in segment 12BW that the ZPMC welding personnel welding in top of the crack tack weld in 3F position for fillet weld joint joining between floor beam to longitudinal Diaphragm at PP114.5 Counter weight Side. For more information refer the attached photo.

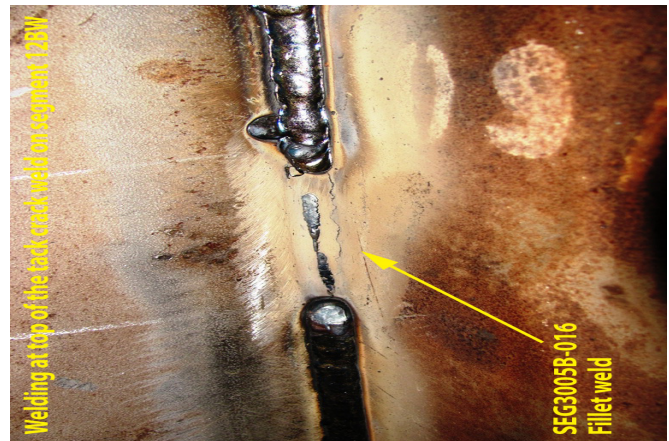
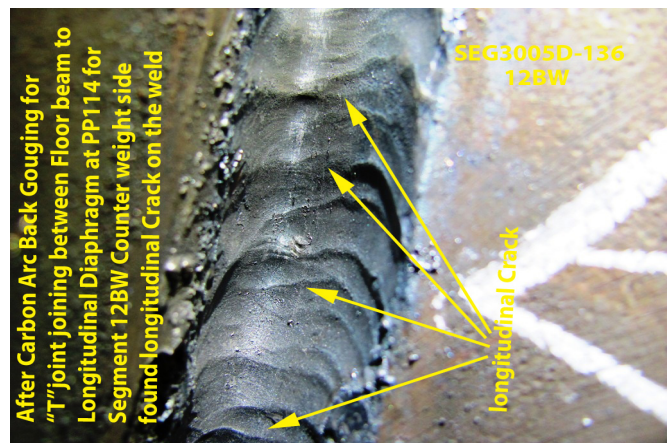
During random visual inspection the QA inspector observed after Carbon Arc Back Gouging for "T" joint joining between Floor beam to Longitudinal Diaphragm at PP114 for Segment 12BW Counter weight side the QA Inspector found Crack center of the entire length of the weld. The weld joints are identified as SEG3005D-016 and SEG3005D-136. After remove the crack the ZPMC MT technician has done Magnetic Particle testing and found accepted. For confirmation the QA Inspector performed magnetic Particle Testing at same area and found longitudinal and transverse linear indication at both of the weld. For more details see the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer